

Date: Thursday, 20/11/2008 3:11:55 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ASPIRATOR
Job Number : 43572	
Estimate Number : 12425	
P.O. Number :	Part Number : D2000111
This Issue : 20/11/2008 S.O. No. :	Drawing Number : D2000-111 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : PURCHASED PARTS	Drawing Revision : A1
Previous Run : 35322	Material :
Written By :	Due Date : 21/12/2008 Qty: 10 Um: Each
Checked & Approved By : <u>2008.11.21</u>	
Comment : Est Rev:A New Issue 06-05-31 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 7655 For D2000-111

Spin as per Dwg D2000-111

Possible Supplier: SIEG

Material release note is required

C208111124

(10)

2.0	D2000111S	Aspirator - Inner Core
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
 Aspirator - Inner Core

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

Pd 12/11 (10)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECKS081212 (10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Drill as per Dwg D2000

Deburr

FF. 09-01-06

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ASPIRATOR

Job Number: 43572

Part Number: D2000111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/01/06

(10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57270

PC 9/01/8

(10)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/09/08

MF 09-08-08

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

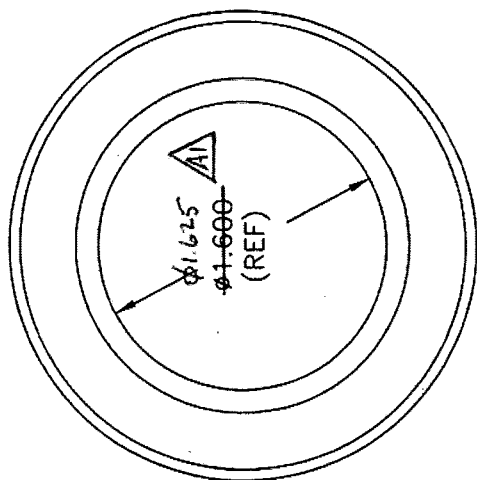
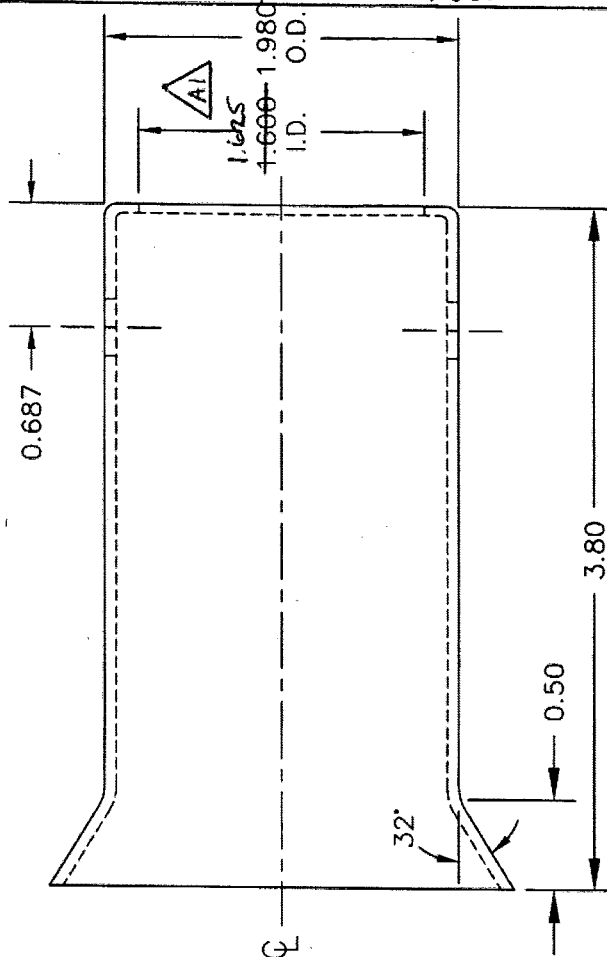
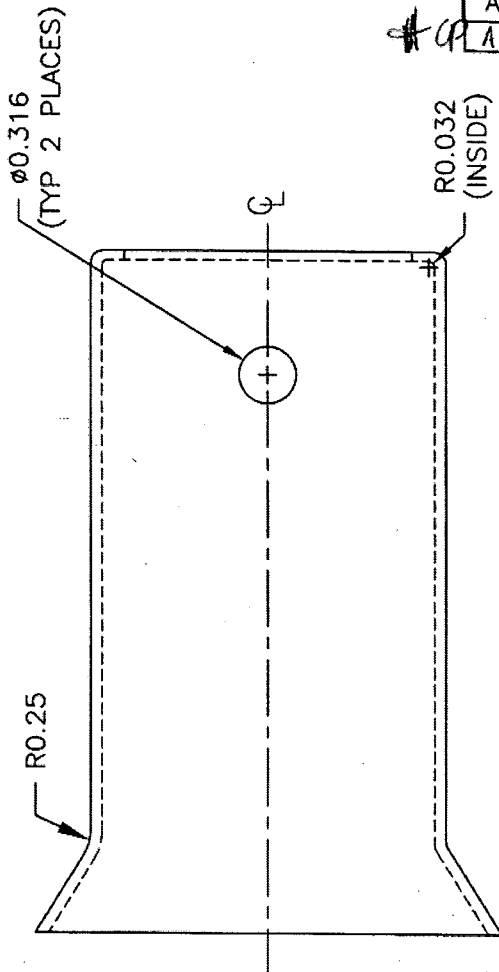
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	JB	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	APPROVED	CP	DRAWING NO.	REV. A
				D2000-111	SHEET 1 OF 1
DATE	00.11.13			TITLE	SCALE
				ASPIRATOR	1:1
A	00.11.13			NEW ISSUE	
A1	01.10.01			1.625 WAS 1.600	



RELEASED

00-11-20

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43512

NOTES:
THIS PART MUST MATE WITH D2000-109
MATERIAL: 1100-0 ALUMINUM (QQ-A-250/1) 0.063 THICK
FINISH: NONE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7

TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: 12/10/08

Customer: Dart Aerospace

Packing Slip: 36124

Part#	Quantity	Material	Check holes	Debur edges	Insp. By.
D2000109S	10	14G	✓	✓	JS
D2000111S	10	14G.	✓	✓	JS
D2060S	20	14G	✓	✓	JS
D2061P	20	14G	n/a	✓	JS

S
0012/12

Notes:

PO# 7655

12/14/11

Material Certification Attached: Yes ~~JS~~

W.H.H. GERRY

ALCOA ALCOA INERT PRODUCTS
1480 Manheim Pike
Lancaster Pa 17601

Certification of Test Results

P/N 970200

PO 38C880

08/30/2007 THU 12:52 FAX

SOLD TO		SHIP TO	

CERT NO 3000575396
DATE 4/23/2007
SKID NO 661032
SKID WGT 9.885
PAGE 1 OF 1

ORDER NO	165947	PO NO	43-62756			MILL FINISH
ITEM NO	1	PART NO				NON AMODIZE QUALITY
ALLOY	1100	TEMPER	O	FORM	COIL	OUT: STANDARD MILL FINISH
GAUGE	.06300	WIDTH	48.0000	LENGTH	0.0000	IN: STANDARD MILL FINISH
						NOT EMBOSSED

LOT: 334171 COIL: B01 DROP: 07T0187

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
U718321	0.12	0.49	0.12	0.02	0.01	0.02	0.01	0.01	0.01

HEAD ULTIMATE STRENGTH 13.1 KSI
TAIL ULTIMATE STRENGTH 13.0 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 5.5 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.3 KSI
HEAD ELONGATION (G.L. = 2 IN) 32 %
TAIL ELONGATION (G.L. = 2 IN) 31.5 %

* AS REPORTED BY SUPPLIER
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-06

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:
ASME SB209 1100 C, AMS 4001H 1100 O,
ASTM B209-06 1100 O, AMS-QQ-A-250/1 1100 O
PAX CERTS: 714-736-4840

** END OF CERTIFICATION **

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material met the composition. Also, note that mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our product. Certification of test results shall not be reproduced except in full.

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Authorized By: JEFF KREADY, LAB SUPERVISOR

Sold to: COPPER & BRASS SALES PO: 38C880 Part: Order No.: 376276

TR clerk signature: *C. J. ...*

